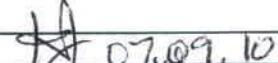


SPLIT

Split SP 07/10/11

Date: Monday, 9/10/2007 1:19:09 PM
 User: Kim Johnston

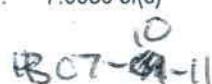
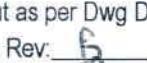
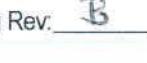
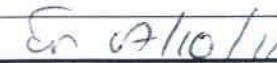
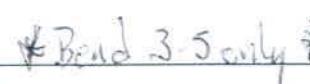
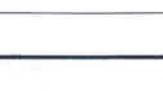
Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 34478 2		
Estimate Number	: 12811		
P.O. Number	: N/A	Part Number	: D35921
This Issue	: 9/10/2007	Drawing Number	: D3592 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 34260	Material	: N/A
Written By	:	Due Date	: 9/17/2007
Checked & Approved By	:  07.09.10	Qty:	48
Comment	: Est Rev.A New Issue 07-03-26 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S125	6061-T6 .125 Sheet
	Comment: Qty.: 0.1460 sf(s)/Unit Total : 7.0056 sf(s) 6061-T6 .125 Sheet Batch: M10448C  ***Grain must be Along 4.63***** GRANITE 45° SEE DWG	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3592 Dwg Rev:  B  Prog Rev:  B	
	2-Deburr if necessary	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Form as per Dwg D3592 using DT8949	
		
		
		
		



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34478

Part Number: D35921

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 9/10/11 (X2)

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WT

11 07-10-11 (2)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



D. Dahlia

u 07-10-12

Job Completion



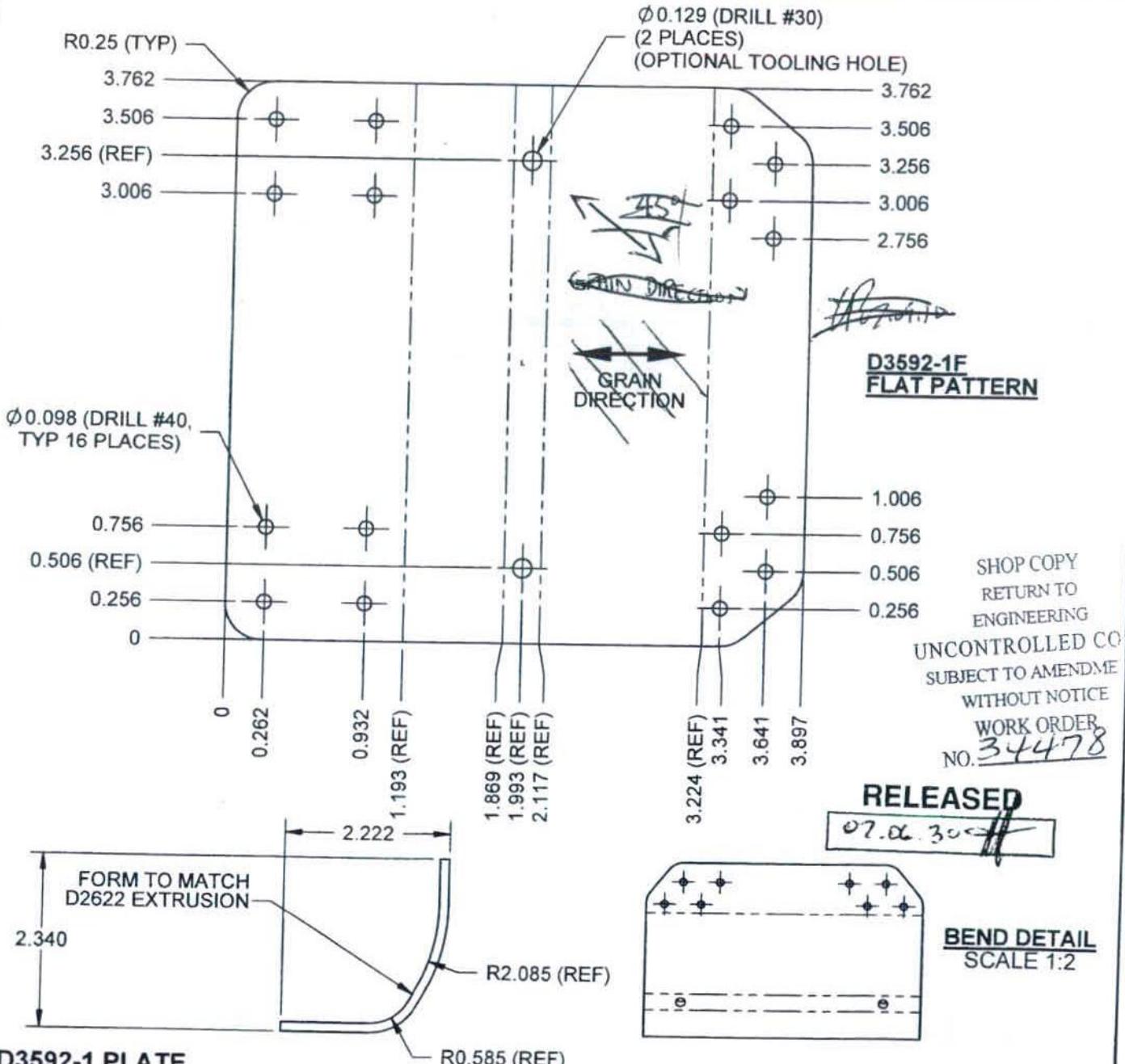
POSITIVE RECALL

EFFECTIVE 07-09-10 AUTH Q
RELEASED 07-09 DATE LN



DART

DESIGN <i>QP</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD	
CHECKED <i>QP</i>	APPROVED <i>HF</i>	HAWKSLEY, ONTARIO, CANADA	
DATE 07.05.31		DRAWING NO. D3592	REV. E
		TITLE PLATE	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**D3592-1 PLATE**

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX



DART AEROSPACE LTD

Work Order:

34478

Description: BRACKET

Part Number:

D3592-1

Inspection Dwg: 3592 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\phi .129$	$+.004 - .001$.130	X			
$\phi .098$	$+.005 - .001$.099	X			
.356	$+.000 -.010$.356	X			
.506	$+.000 -.010$.506	X			
.756	$+.000 -.010$.756	X			
3.006	$+.000 -.010$	3.006	X			
3.256	$+.000 -.010$	3.256	X			
3.506	$+.000 -.010$	3.506	X			
3.762	$+.000 -.010$	3.762	X			
2.756	$+.000 -.010$	2.756	X			
1.006	$+.000 -.010$	1.006	X			
.262	$+.000 -.010$.262	X			
.932	$+.000 -.010$.932	X			
1.193	$+.000 -.010$	1.193	X			
R.25 +.061	$+.000 -.030$.25	X			
1.943	$+.000 -.010$	1.943	X			
.247						
3.341	$+.000 -.010$	3.341	X			
3.641	$+.000 -.010$	3.641	X			
3.891	$+.000 -.010$	3.900	X			
.125	$+.000 -.010$.122	X			

Measured by:	HB
Date:	07-10-11

Audited by:	SR
Date:	07/10/11

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/06/11	5	Split WO 8			S. Oktakulu	2			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

